



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D3393-1

Job Sheet 192215



Part No: D3393-1

Job Qty: 10 pcs

Part Name: Battery Lock Casing



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 3/19/19

Job Tracking No:

Due Date: 4/19/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV A IPP A 05.02.18 New issue KJ/JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Lead Time	Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier			
100	Bandsaw - 1	10 pcs	4/19/19	4/19/19	0.00	0.02	Bandsaw - 1		DAS 52 ⁹⁻⁸⁹	19/03/27
110	HAAS 4 Axis - B4B	10 pcs	4/19/19	4/19/19	0.33	5.13	HAAS - 1 - B4B		DAS 52 ⁹⁻⁸⁹	19/03/27
							HAAS - 2 - B4B		9-89	
							HAAS - 3 - B4B			
							HAAS - 4 - B4B			
130	QC 8	10 pcs	4/19/19	4/19/19	0.00	0.00	QC 8 - 12			
							QC 8 - 14			
							QC 8 - 17			
							QC 8 - 20	23		19/3/28
							QC 8 - 25			
							QC 8 - 3			
							QC 8 - 32			
							QC 8 - 33			
							QC 8 - 35			
							QC 8 - 39			
							QC 8 - 4			
							QC 8 - 44			
							QC 8 - 45			
							QC 8 - 49			
							QC 8 - 58			
							QC 8 - 8			
							QC 8 - 9			
							QC 8 - 68			
							QC 8 - 67			
							QC 8 - 1 (A)			
							QC 8 - 47			
							QC 8 - 40			
140	Handfinish - 1-1 Chemical-B4B	10 pcs	4/19/19	4/19/19	0.00	0.30	Handfinish - 1 - 1 - B4B			
							Handfinish - 1 - 2 - B4B			
							Handfinish - 1 - 3 - B4B			



Container No: S166989



Part: D3393-1

Job No: 192215

Serial No/Batch: S166989

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
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Date: 03/27/19

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				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	D.R. 1%
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
150 Powdercoat - 6 Fire Red - B4B	10	4/19/19	0.00 0.37	Powdercoat - 1 - B4B	
M129223	pcs			Powdercoat - 2 - B4B	
				Powdercoat - 3 - B4B	
				Powdercoat - 4 - B4B	
160 QC 3	10	4/19/19	0.00 0.00	QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 68	
				QC 3 - 9	
				QC 3 - 40	
				QC 3 - 19	
170 Packaging 3-1 - Stock - B4B	10	4/19/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	

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					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	51501 * APR 02 2019
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	DAS
180 QC 21 - SA	10 pcs	4/19/19	0.00 0.00		QC 21 - SA - 21	21
					QC 21 - SA - 70	9-35
					QC 21 - SA - 53	APR 02 2019

Part Op **100** - (Bandsaw) Cut blank: 1.500" x 1.500" x 3.125" long
 Descriptions: **110** - (HAAS CNC Vertical Machine) Machine D3393-1 as per Folio FA510 and Dwg D3393 Identify as D3393-1
130 - (QC8- Inspect parts - second check)
140 - (Chemical Conversion Coat per QSI005 4.1)
150 - (Fire Red(Ref:4.3.5.10) per QSI005 4.3) START TIME: _____
160 - (QC3- Inspect Part Finish)
170 - (Identify as per dwg & Stock Location: _____)
180 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B1.500X1.500	6061-T6 Bar 1.50 X 1.50	2.7080 ft (.2708 ea)	100-Bandsaw - 1	SV 7526

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	M6061T6B1.500X1.500	3	16	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Battery Lock Casing	0.750Inches $\pm$ 0.010	0.760 0.740	Diameter	0.752
2	Battery Lock Casing	0.625Inches $\pm$ 0.010	0.635 0.615		0.628
3	Battery Lock Casing	1.250Inches $\pm$ 0.010	1.260 1.240	Diameter	1.250
4	Battery Lock Casing	1.088Inches $\pm$ 0.010	1.098 1.078		1.088
5	Battery Lock Casing	0.734Inches $\pm$ 0.010	0.744 0.724	Diameter	0.734
6	Battery Lock Casing	2.658Inches $\pm$ 0.010	2.668 2.648		2.658
7	Battery Lock Casing	1.550Inches $\pm$ 0.010	1.560 1.540		1.550
8	Battery Lock Casing	0.125Inches $\pm$ 0.010	0.135 0.115		0.125
9	Battery Lock Casing	45.000Degrees $\pm$ 5.000	50.000 40.000	Angle	45°
10	Battery Lock Casing	1.500Inches $\pm$ 0.030	1.530 1.470		1.490
11	Battery Lock Casing	0.750Inches $\pm$ 0.010	0.760 0.740		0.745
12	Battery Lock Casing	1.050Inches $\pm$ 0.010	1.060 1.040	Diameter	1.050
13	Battery Lock Casing	1.000Inches $\pm$ 0.010	1.010 0.990	Diameter	1.000
14	Battery Lock Casing	0.338Inches $\pm$ 0.010	0.348 0.328		0.338
15	Battery Lock Casing	0.563Inches $\pm$ 0.010	0.573 0.553		0.563
16	Battery Lock Casing	0.100Inches $\pm$ 0.000 - 0.010	0.100 0.090		0.099
17	Battery Lock Casing	3.000Inches $\pm$ 0.030	3.030 2.970		3.005
18	Battery Lock Casing	1.500Inches $\pm$ 0.010	1.510 1.490		1.502
19	Battery Lock Casing	0.375Inches $\pm$ 0.010	0.385 0.365		0.375
20	Battery Lock Casing	1.250Inches $\pm$ 0.030	1.280 1.220		1.246
21	Battery Lock Casing	0.125Inches $\pm$ 0.010	0.135 0.115		0.125
22	Battery Lock Casing	30.000Degrees $\pm$ 0.500	30.500 29.500	Angle	30°

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